

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021938**Date Inspected:** 24-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

Components: 13AW

PCMK: SEG3013F-109

Welder: 068445

WPS-B-T-2232-ESAB

PCMK: SEG3013F-018

Welder: 066734, 203871

WPS-B-T-2232-ESAB

Components: 14W

PCMK: SEG3020BB-110

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welder: 067949

WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shield Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

Components: 14W

PCMK: SEG3020Y-022

Welder: 047864

Report: B-CWR2792 Rev,-2

WPS-345-SMAW-3G (3F)-FCM-repair-1

PCMK: SEG3020Z-004,005

Welder: 067609, 067764, 066038

WPS-B-P-2214-TC-U5-FCM-1

Components: Deck Panel

PCMK: DP3173-001-020

Welder: 066480

Report: B-WR20289

WPS-345-SMAW-2G (2F)-FCM-repair-1

PCMK: DP3172-001-018

Welder: 037780

WPS-B-P-2212-TC-U4b-FCM

13AE

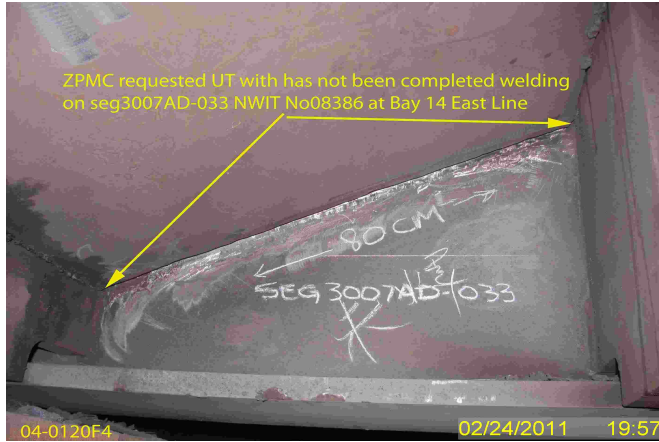
This QA inspector performed Ultrasonic Testing (UT) of approximately 10 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) is/are identified as follows; SEG3007AD-029, 031,033 on item number 6, of NWIT tracker document # 08386,

Remark: weld No 033 has partial tested, (100 cm from bottom plate to side panel weld joint, welding was not completed, Due to ZPMC has limited access for welding on this area from support jig)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

| | | |
|----------------------|-----------|-----------------------------|
| Inspected By: | Shin,DJ | Quality Assurance Inspector |
| Reviewed By: | Riley,Ken | QA Reviewer |
